

Date: Monday, 7/9/2007 11:42:25 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SLIDE BAR
Job Number	33335		
Estimate Number	11085		
P.O. Number	N/A	Part Number	D30111
This Issue	7/9/2007	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D3011 REV A
First Issue	N/A	Project Number	N/A
Previous Run	26219	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By	<u>KJ</u> 07.07.09	Due Date	7/30/2007
Comment	Est. C 02.05.09	Qty:	6
	Added D6202 at step 2 NG	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6202	I Beam Extrusion
		Comment: Qty.: 1.0000 f(s)/Unit Total : 4.0000 f(s) I Beam Extrusion Material: 6061-T6 (QQ-A-200/8) 'I' Beam Extrusion 4" x 2.796" x 0.326" Batch <u>B14742</u>
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut Blanks: 26.57"
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Ensure Batch Number programmed matches this W/O Machine as per folio FA129
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3011-1 PAR #: N/A Fault Category: Prod/Machine Parts NCR: Yes No DQA: Date: 07/11/22
 QA: N/C Closed: Date: 07/11/23

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/15	3.0	1 piece scrap the dim. 2.500" are too thin 2.475" (Prog error.)	07/11/20	Scrap replaced destroy we changed the prog.	07/11/15	07/11/20	07/11/20	07/11/20
07/11/16	3.0	2 piece scrap the dim. 1.200" are too thin one 1.100 and 1.090	07/11/20	Scrap and destroy no replace	07/11/16	07/11/20	07/11/20	07/11/20

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDE BAR

Job Number: 33335

Part Number: D30111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SS

07-11-20

XU

7.0 POWDER COATING

POWDER COATING



M 105914

④

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL

07-11-20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 266

SS 07/11/21

④

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/11/22

④

Job Completion



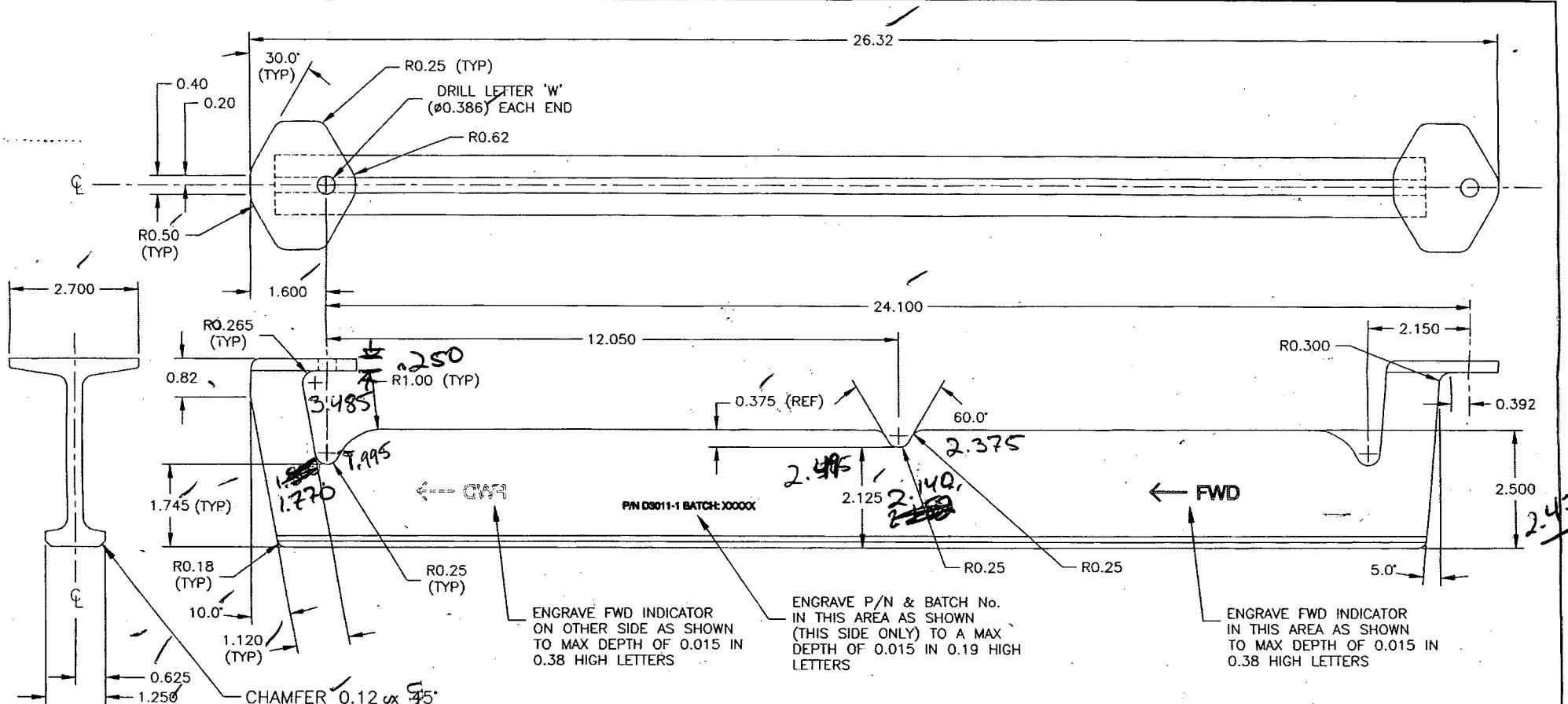
11 07.11.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
01.04.09

COPY ISSUED
01.04.09

D3011-1
MANUFACTURE FROM D6202-027 EXTRUSION
BREAK ALL SHARP EDGES 0.010-0.020

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED
SUBJECT TO AMENDMENT
NO. 2333
WITHOUT NOTICE
WORK ORDER NUMBER

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DART AEROSPACE LTD.

A	01.03.29	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3011
DATE		SHEET 1 OF 1
01.03.29		SCALE
		1:2
		RAPPAL SLIDE BAR

3. u11

DART AEROSPACE LTD	Work Order:	33335
Description: rappel slide bar	Part Number:	D3011-1
Inspection Dwg: D3011 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.32	$\pm .030$	26.32	✓			
30°	$\pm 1/2^\circ$	30°	✓			
.40	$\pm .030$.408	✓			
.386	$\pm .005$ $\pm .001$.388	✓			
1.600	$\pm .010$	1.599	✓			
2.700	$\pm .010$	2.704	✓			
1.250	$\pm .010$	1.252	✓			
.12X45°	$\pm .030$ $\pm 1/2^\circ$.115X45°	✓			
1.120	$\pm .010$	1.121	✓			
1.745	$\pm .010$	1.741	✓			
10°	$\pm 1/2^\circ$	10°	✓			
.82	$\pm .030$.812	✓			
24.100	$\pm .010$	24.101	✓			
.375	$\pm .010$.376	✓			
2.125	$\pm .010$	2.119	✓			
2.500	$\pm .010$	2.491	✓			
1.25	$\pm .030$	1.250	✓			
5°	$\pm 1/2^\circ$	5°	✓			
60°	$\pm 1/2^\circ$	60°	✓			

Measured by:	J.L	Audited by:	RD	Prototype Approval:	
Date:	07/11/17	Date:	07/11/17	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	